



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4073-3

Job Sheet 172584



Part No: D4073-3

Job Qty: 20 ea

Part Name: Door Hinge Backing Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/20/18

Job Tracking No:

Due Date: 3/9/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B SHEET 2 IPP Rev:A 10.06.08 new issue DD ver:EC IPP REV:B DRAWING REV. CHANGE AS PER ECN 11-598 11-07-05 JFS VERIFIED BY:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	3/8/18	3/8/18	0.00	0.00	Start Up Waterjet		2 18/02/22
100	Waterjet	20 pcs	3/8/18	3/8/18	0.00	0.61	Waterjet1		2 18/02/22
120	QC	20 pcs	3/8/18	3/8/18	0.00	0.00	QC8		2 B
130	HandFinish	20 pcs	3/8/18	3/8/18	0.00	0.34	HandFinish1		2 18/02/22
140	Powdercoat	20 pcs	3/9/18	3/9/18	0.00	0.19	Powdercoat1		2 18/02/22
150	QC	20 pcs	3/9/18	3/9/18	0.00	0.00	QC3		2 18/02/22
160	Packaging	20 pcs	3/9/18	3/9/18	0.00	0.00	Packaging3	STO 73	2 18/02/22
170	QC21-SA	20 Ea	3/9/18	3/9/18	0.00	0.00	QC21		2 18/02/22

Part Op 100 - 1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary
 Descriptions: 120 - QC8- Inspect parts - second check
 130 - Chemical Conversion Coat per QSI005 4.1
 140 - White Gloss (Ref:4.3.5.1) per QSI005 4.3-Alum POWDER COAT: Start Time: 4:15 Oven Temperature: 500 Finish Time: 4:45 M138467
 150 - QC3- Inspect Part Finish
 160 - Identify as per dwg & Stock Location:
 170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	.5554 sf (.02777 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	1	252	0



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Container No: S044672



Part: D4073-3

Job No: 172584

Serial No/Batch: S044672

Revision: D4073

Inspector:

Date: 02/22/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Hinge Backing Plate	0.203Inches + 0.005 - 0.001	0.208 0.202	0.204	Diameter
2	Door Hinge Backing Plate	2.000Inches ± 0.030	2.030 1.970	2.000	
3	Door Hinge Backing Plate	1.320Inches ± 0.010	1.330 1.310	1.322	
4	Door Hinge Backing Plate	0.340Inches ± 0.030	0.370 0.310	0.341	
5	Door Hinge Backing Plate	0.350Inches ± 0.030	0.380 0.320	0.351	
6	Door Hinge Backing Plate	1.800Inches ± 0.030	1.830 1.770	1.800	
7	Door Hinge Backing Plate	1.100Inches ± 0.010	1.110 1.090	1.101	
8	Door Hinge Backing Plate	0.063Inches ± 0.010	0.073 0.053	0.060	

Plex 2/20/18 2:47 PM Dart.Gagnon.Michelle